

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR27		N/C
N/C	INITIAL RELEASE	06-15-16	P. BRAVO
A	INCORPORATED ECN 05570	09-06-16	P. BRAVO
B	INCORPORATED ECN 05887	02-02-18	P. BRAVO
C	INCORPORATED ECN 06453	02-24-20	J. GARDINER

NOTES: UNLESS OTHERWISE SPECIFIED

- 1

DELETED
- 2

IDENTIFY IAW MPP-120
- 3

DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .015" TO .030" AROUND PART EXTERIOR EDGE
- 4

FINISH: BRUSHED
- 5

FINISH: IAW MPP-172 PRIMER IAW SECTION 4.2
- 6

DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .005" TO .010" AROUND PART EXTERIOR EDGE
- 7

100% LOT INSPECTION, CRITICAL FEATURE
- 8

INSTALL F/N 17, JOINING F/N 13 OR 14 WITH F/N 5 IAW NAS10997AD3-5 SPECIFICATIONS
- 9

MASK INSIDE OF F/N 5 BEFORE APPLYING PRIMER.
- 10

MATERIAL: HALF HARD 301 STAINLESS STEEL PER AMS 5518.
- 11

SCORE SURFACE, BEFORE APPLYING PRIMER, USING 40 GRIT SAND PAPER
- 12

PRIMER FINISH: PC 4426, VENDOR: ROYAL ADHESIVES & SEALANTS
- 13

DIMENSIONS FOR FLAT PATTERN DRIVEN BY .DXF FILE
- 14

MATERIAL: P/N 600.0025, SEE SPEC AMS-021 REV B
- 15

MATERIAL: 316 STAINLESS STEEL PER AMS 5524
- 16

MATERIAL: 304 STAINLESS STEEL IAW 5640, 0.016" THICKNESS

		19	648.3548	DOOR PIN GUARD	<div>16</div>	
		18	648.3547	DOOR PIN GUARD	<div>16</div>	
12	12	17	601.3200	REDUCED CSK RIVET		NAS1097AD3-5
		16	648.3544	DOUBLER RUB STRIP	<div>14</div>	<div>13</div>
		15	348.3543	DOUBLER RUB STRIP	<div>14</div>	<div>13</div>
1		14	648.3542	RESERVOIR BRACKET DOUBLER	<div>15</div>	
	1	13	648.3541	RESERVOIR BRACKET DOUBLER	<div>15</div>	
		12	648.3540	FWD GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		11	648.3539	AFT FLT RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		10	648.3538	AFT FLT LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		9	648.3537	AFT RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		8	648.3536	MID RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		7	648.3546	GIRT BACKING STRIP	<div>10</div>	<div>4</div> <div>5</div>
		6	648.3545	GIRT BASE STRIP	<div>10</div>	<div>11</div> <div>12</div>
6	6	5	651.0601	BUSHING ASSY		
		4	648.3535	FWD RH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		3	648.3534	AFT LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		2	648.3533	MID LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
		1	648.3532	FWD LH GIRT STRIP	<div>10</div>	<div>11</div> <div>12</div>
X		X	648.3506	BOTTOM AFT DOUBLER ASSY		<div>5</div> <div>9</div>
	X	X	648.3505	TOP FWD DOUBLER ASSY		<div>5</div> <div>9</div>
.3506	.3505	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY						

PARTS LIST							
NEXT ASSY (S) 648.3300		ORIGINAL DATE (MO-DA-YR) 08-19-10		<div><div><div>DART</div><div>AEROSPACE</div><div>APICAL INDUSTRIES, INC. dba DART AEROSPACE</div></div><div>3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300</div></div> <div>SHEETMETAL</div>			
		DRAWN BY E.ANDERSSON					CHECKER P. BRAVO
		DRAWING APPROVAL P. BRAVO					
		6-15-16					
		CONTRACT No.					
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.010 3 PLACE DECIMALS ±.005 ANGLES ± .3°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500	REV. C
				SCALE NONE		SHEET 1 OF 12	

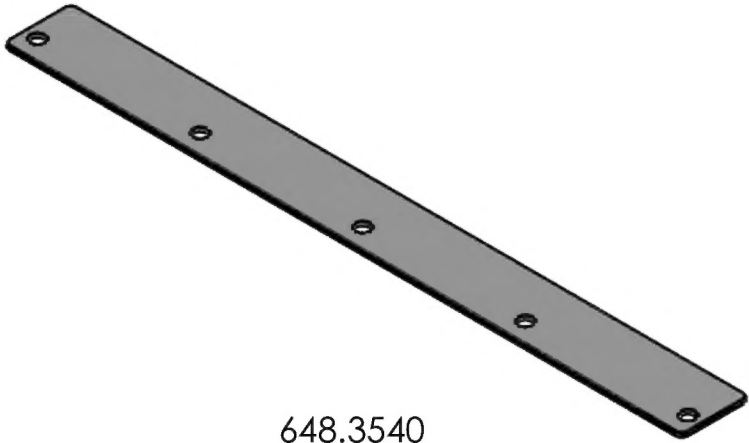
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A

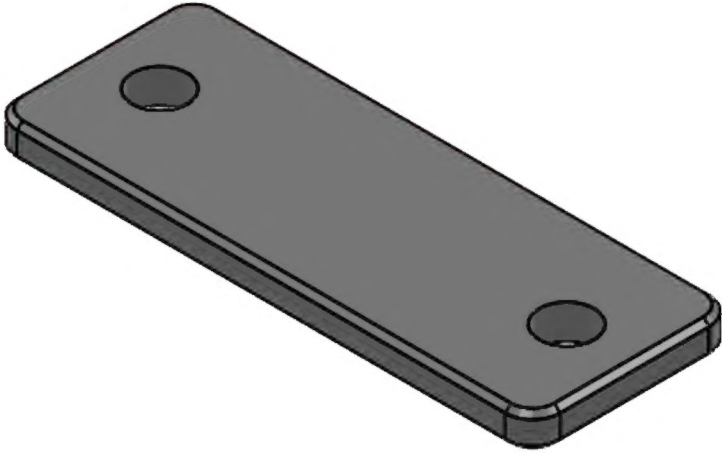
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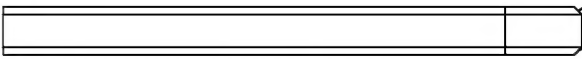
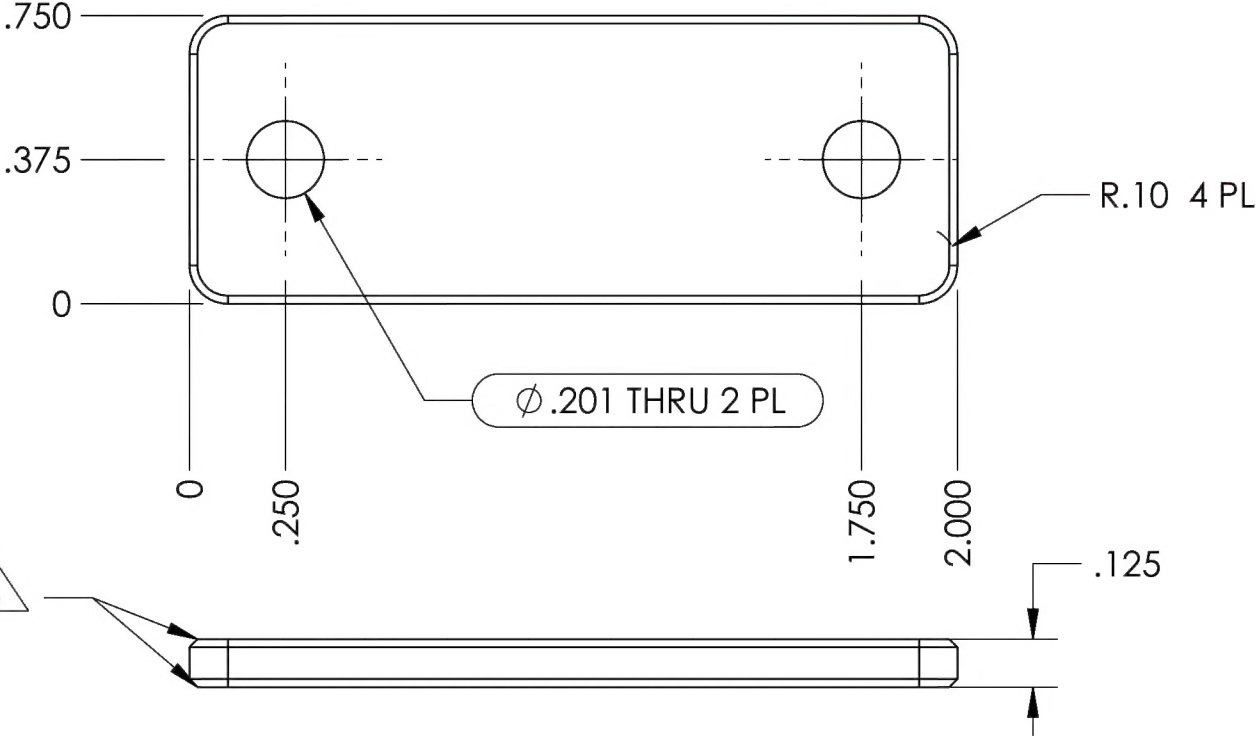
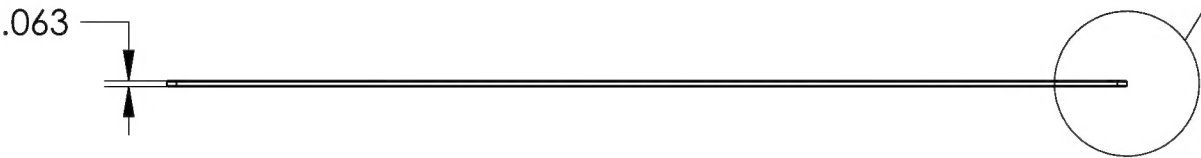
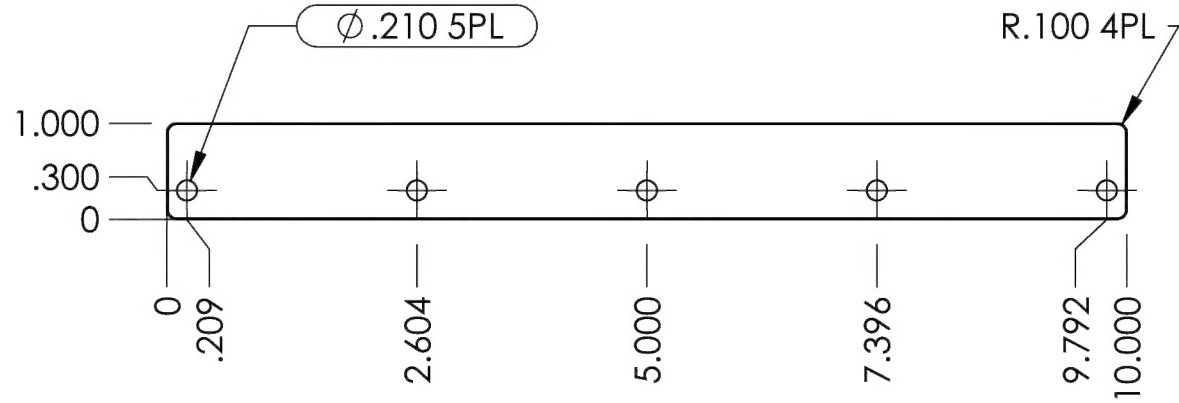
D



648.3540



648.3545



DETAIL A

ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
DRAWING APPROVAL P.BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 648.3500
		SCALE NONE	SHEET 2 OF 12

A

B

9

D



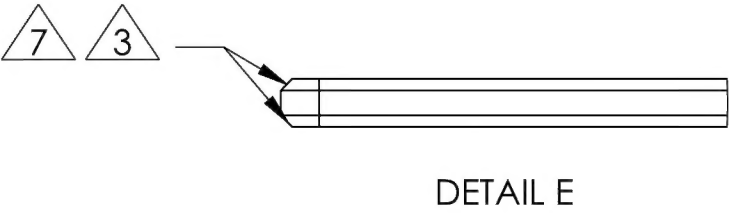
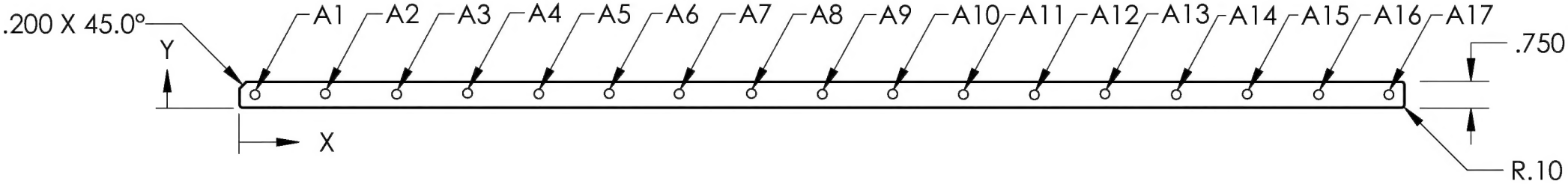
ORIGINAL DATE (MO-DA-YR) 08-19-10	 3030 ENTERPRISE CT. SUITE A VISTA, CA. 92081 (760)-724-5300		
DRAWN BY E.ANDERSSON CHECKER P. BRAVO	APICAL INDUSTRIES, INC. dba DART AEROSPACE		
DRAWING APPROVAL P. BRAVO 6-15-16	CONTRACT No.		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.1°	SHEETMETAL		
	SIZE	CAGE CODE	DWG. NO.
	B	07MZ6	648.3500
	SCALE NONE	SHEET 3 OF 12	

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TAG	X LOC	Y LOC	SIZE
A1	.444	.375	Ø .261 THRU ALL
A2	2.398	.402	Ø .261 THRU ALL
A3	4.384	.388	Ø .261 THRU ALL
A4	6.357	.415	Ø .261 THRU ALL
A5	8.336	.396	Ø .261 THRU ALL
A6	10.294	.405	Ø .261 THRU ALL
A7	12.240	.398	Ø .261 THRU ALL
A8	14.250	.407	Ø .261 THRU ALL
A9	16.221	.389	Ø .261 THRU ALL
A10	18.180	.394	Ø .261 THRU ALL
A11	20.145	.381	Ø .261 THRU ALL
A12	22.119	.370	Ø .261 THRU ALL
A13	24.080	.396	Ø .261 THRU ALL
A14	26.064	.377	Ø .261 THRU ALL
A15	28.036	.391	Ø .261 THRU ALL
A16	30.022	.378	Ø .261 THRU ALL
A17	31.980	.375	Ø .261 THRU ALL



648.3539



DETAIL E

ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300			
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO				
DRAWING APPROVAL P.BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE			
CONTRACT No.		SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500	REV. C
		SCALE NONE		SHEET 4 OF 12	

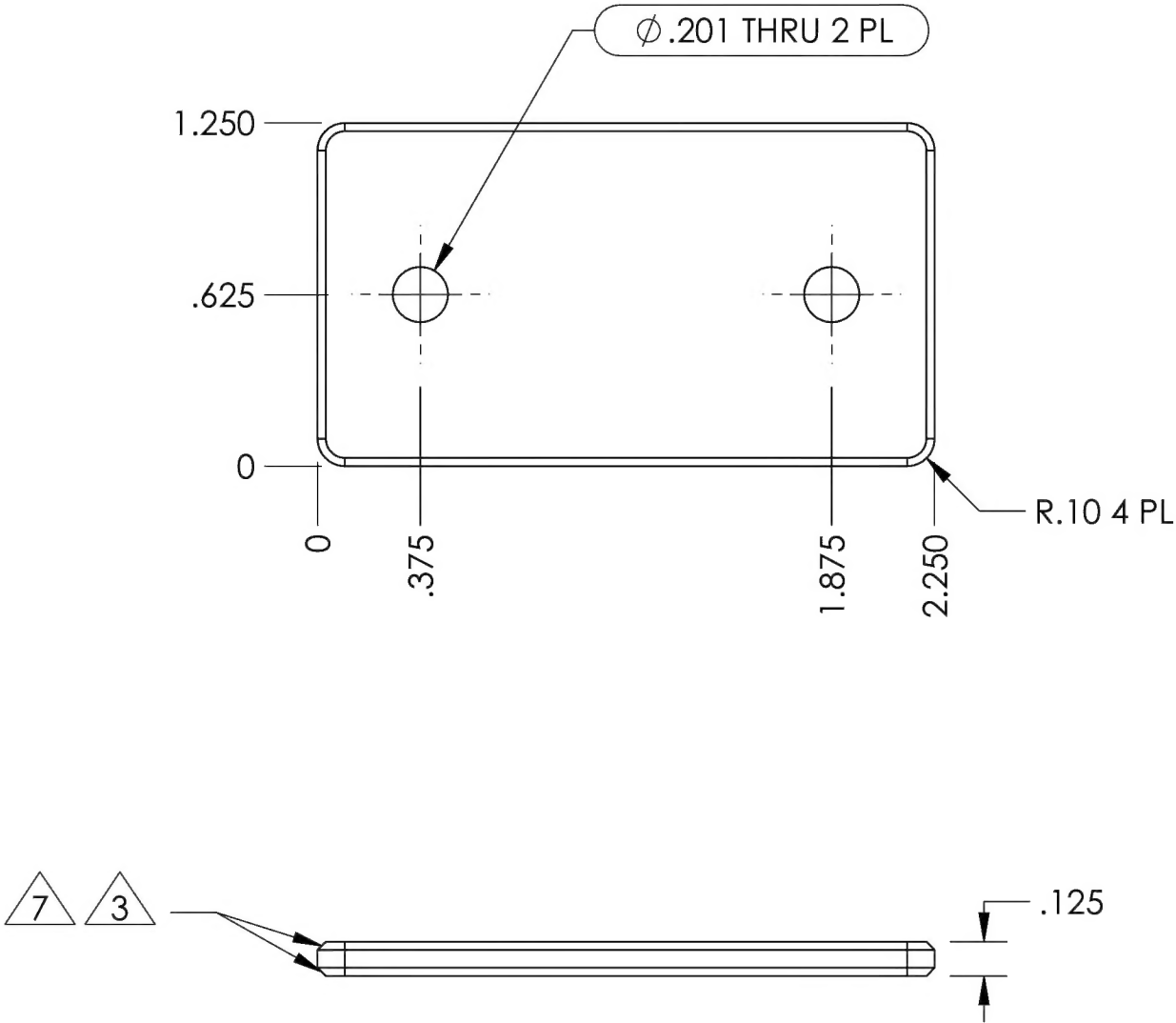
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A

B

C

D

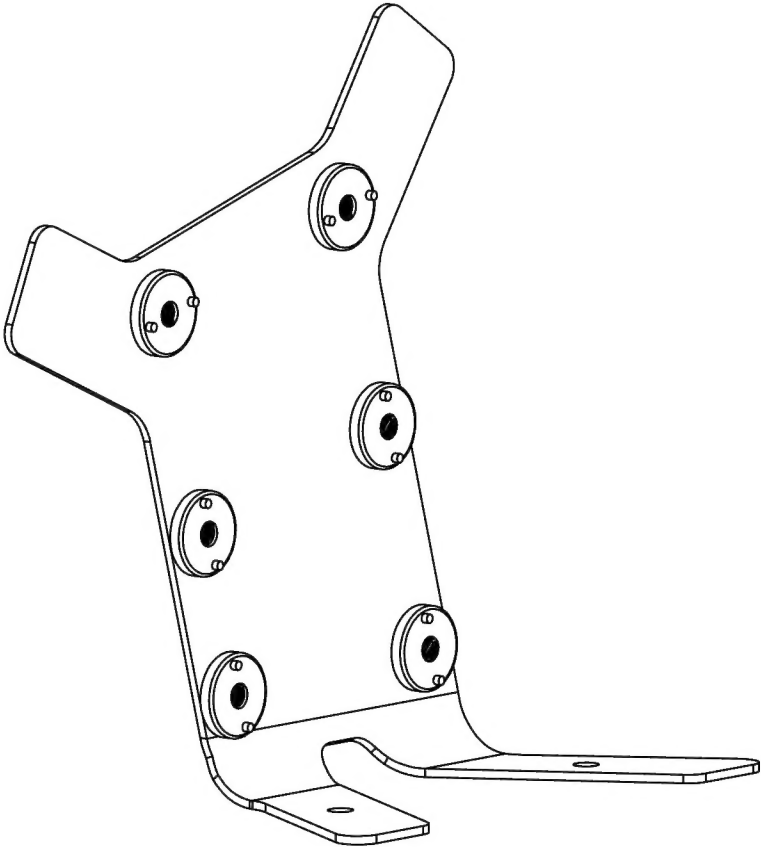
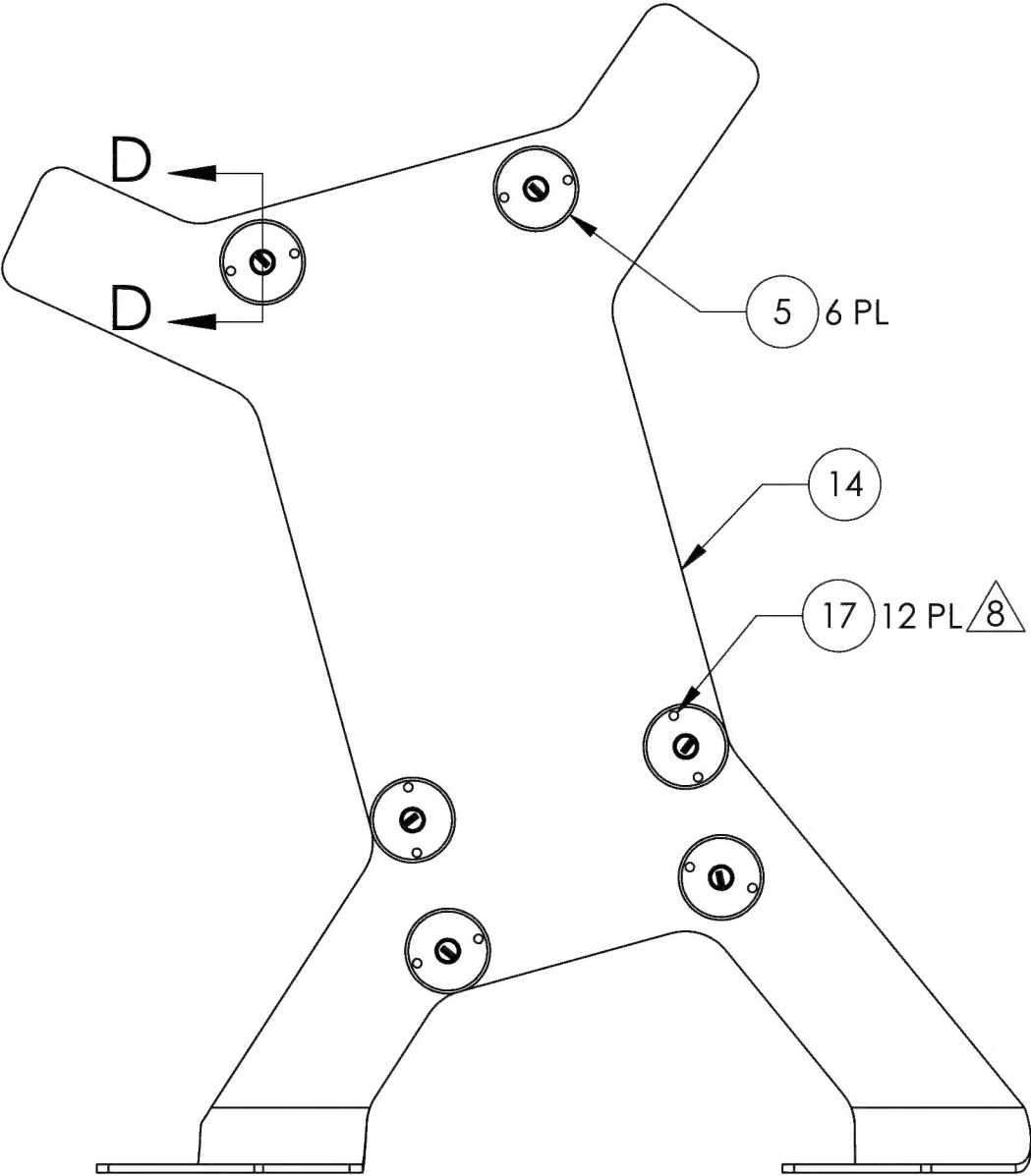
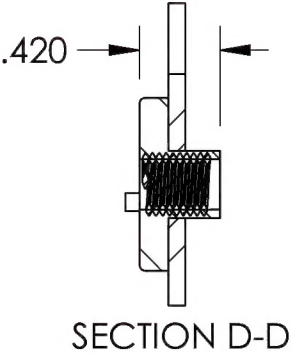
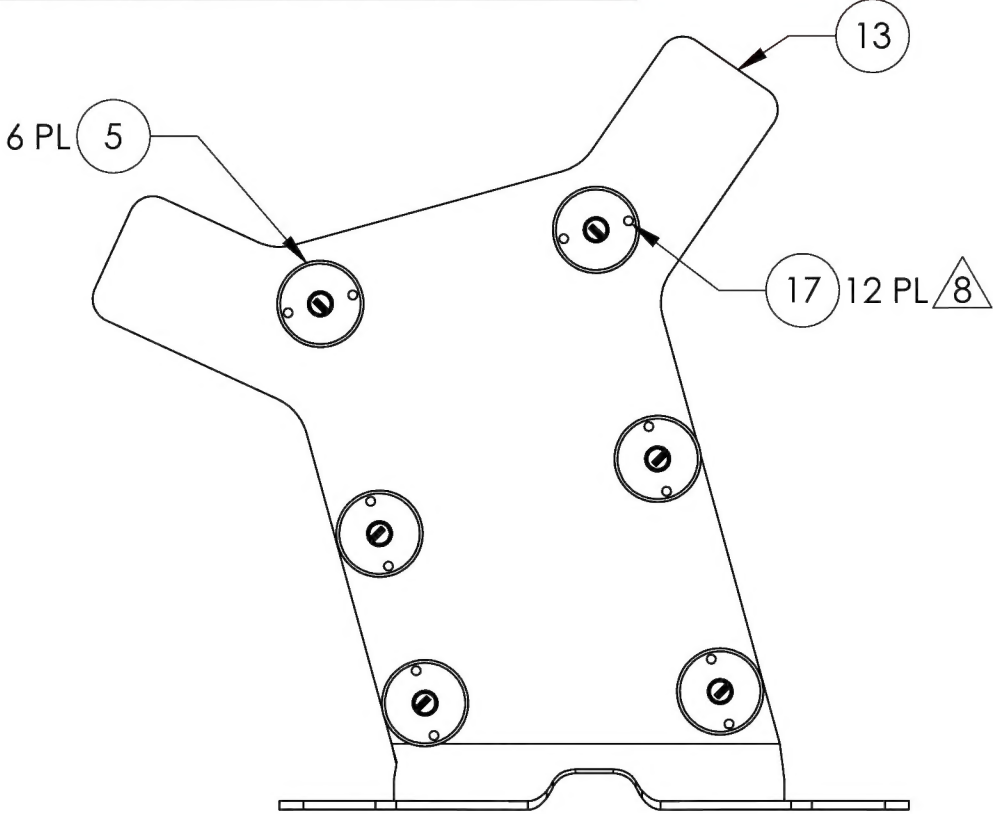


648.3546

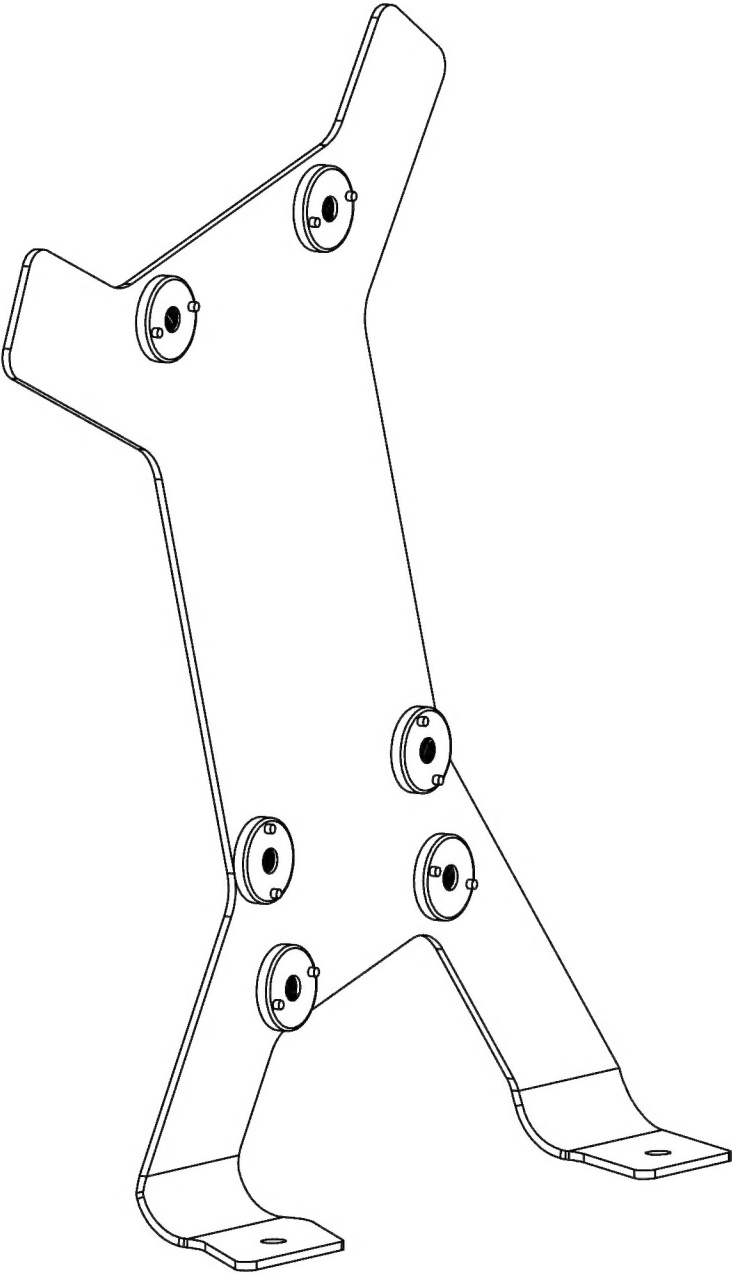
ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
DRAWING APPROVAL P.BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 648.3500
		SCALE NONE SHEET 5 OF 12	

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A
B
C
D



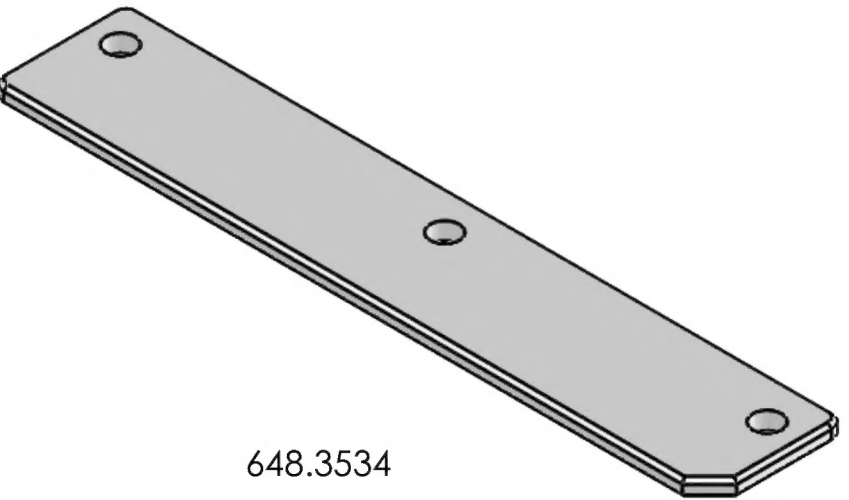
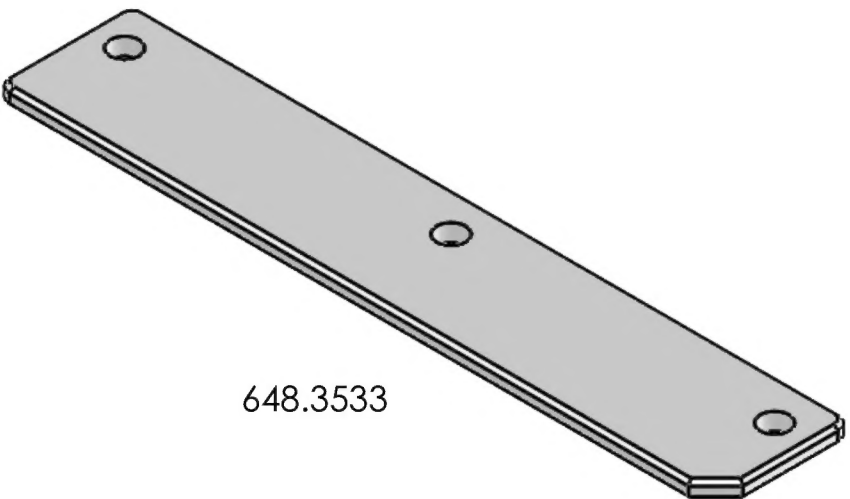
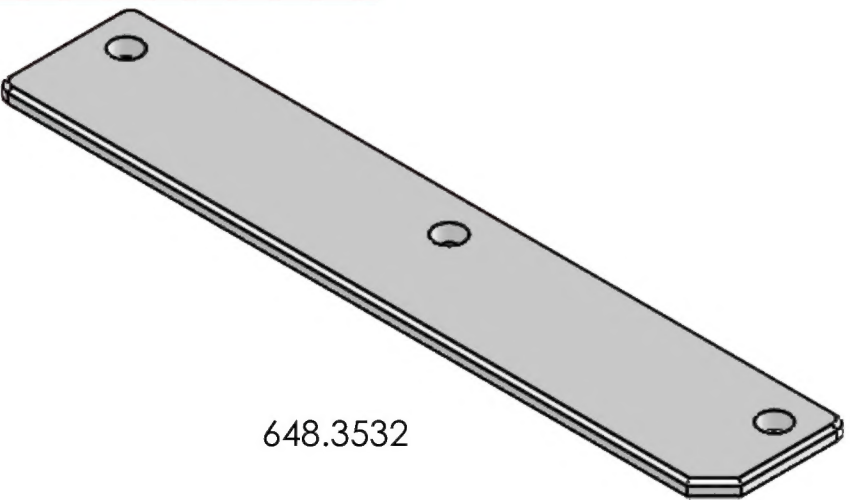
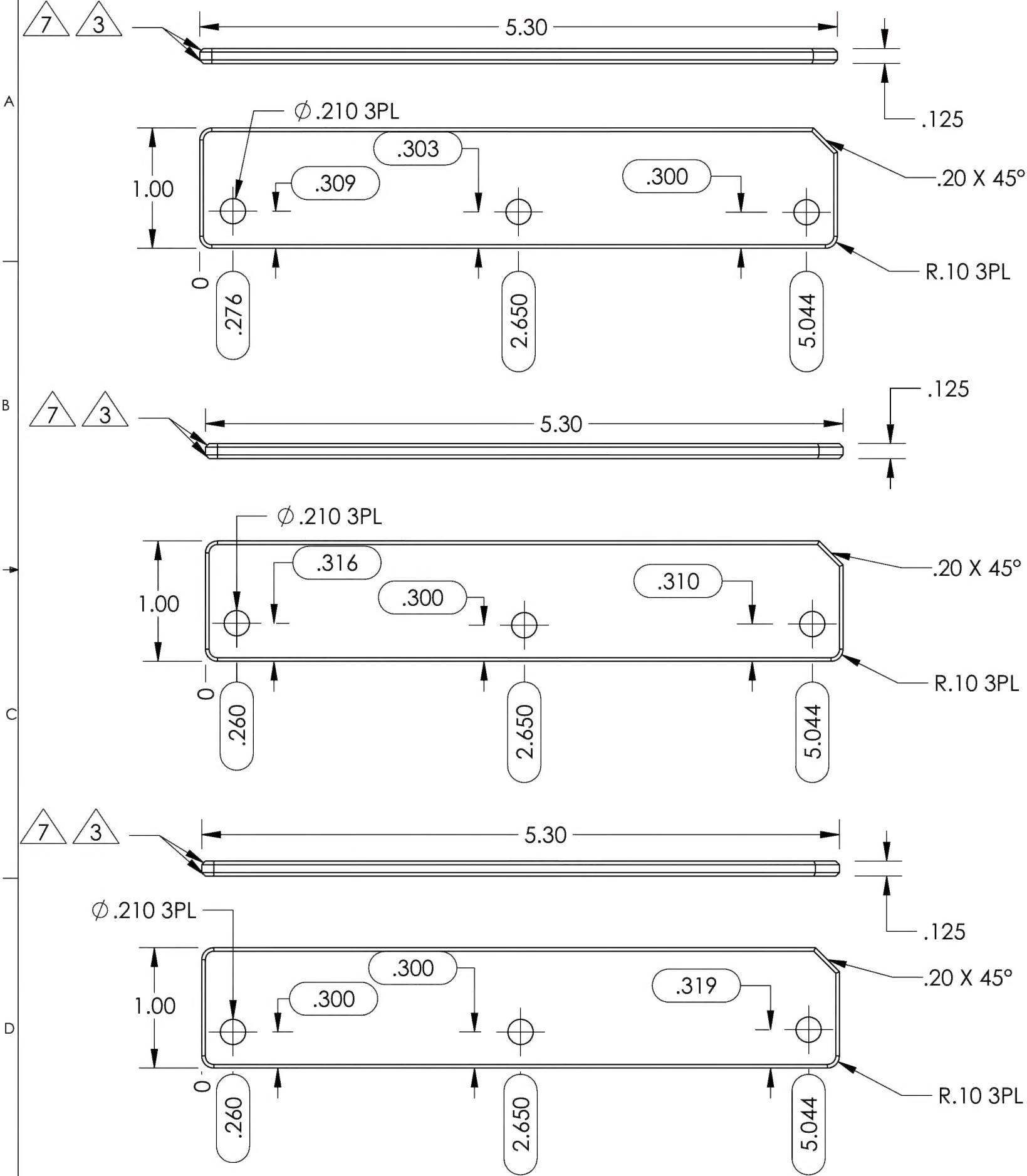
648.3505



648.3506

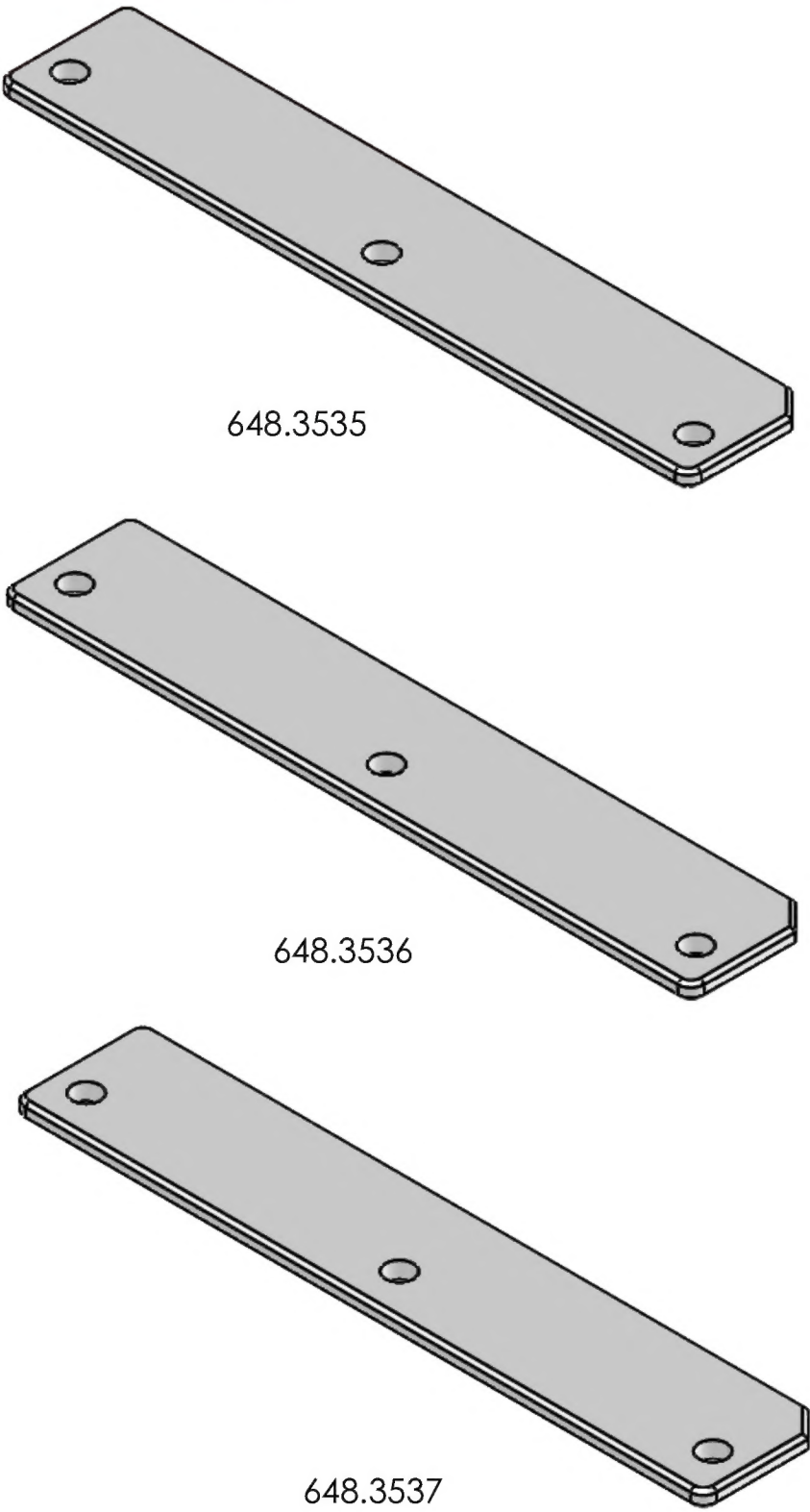
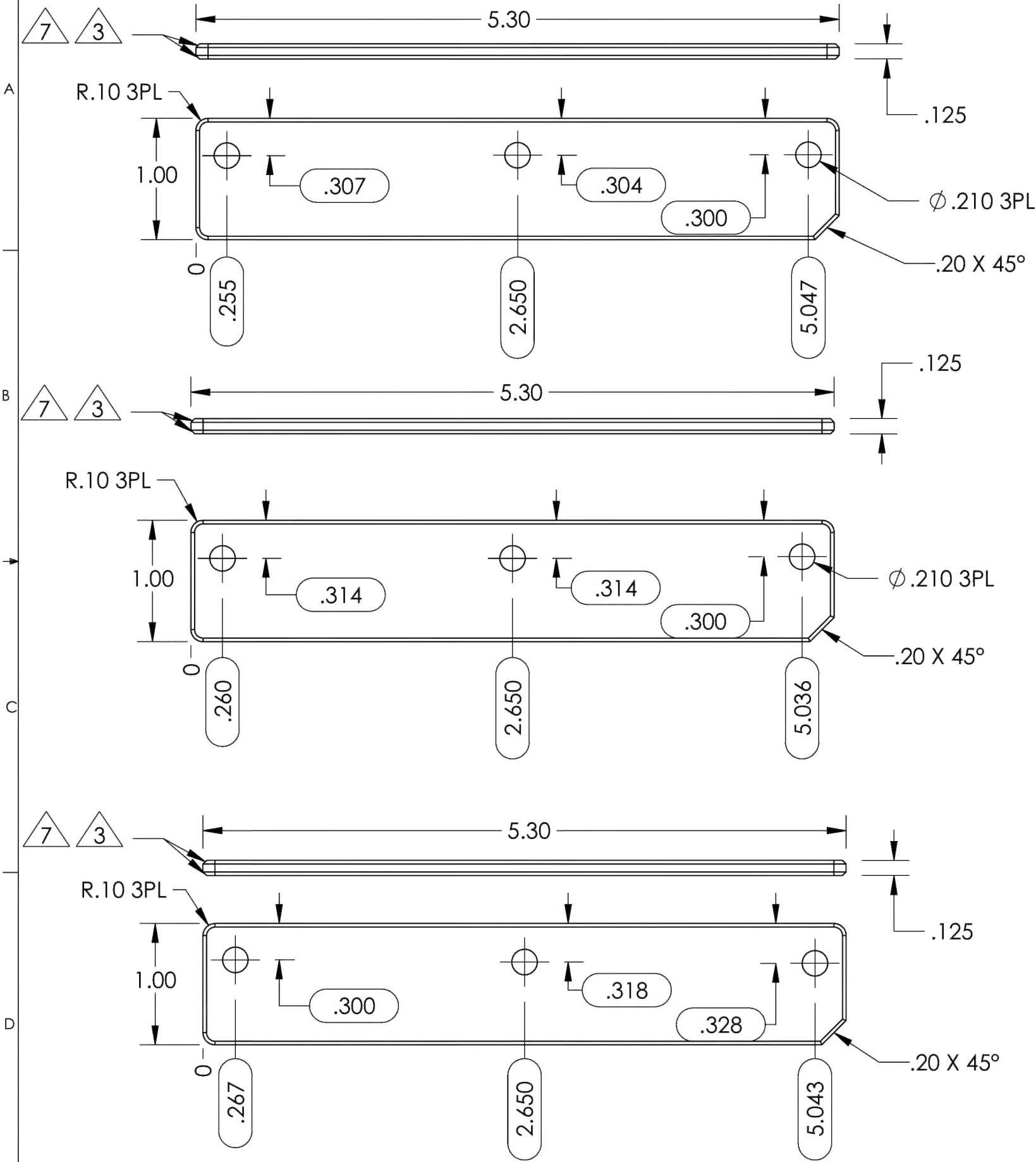
ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES, INC. dba DART AEROSPACE			
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO				
DRAWING APPROVAL P.BRAVO 6-15-16					
CONTRACT No.		SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500	REV. C
		SCALE NONE		SHEET 6 OF 12	

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DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
DRAWING APPROVAL P.BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B 07MZ6	REV. C
		DWG. NO. 648.3500	
SCALE NONE		SHEET 7 OF 12	

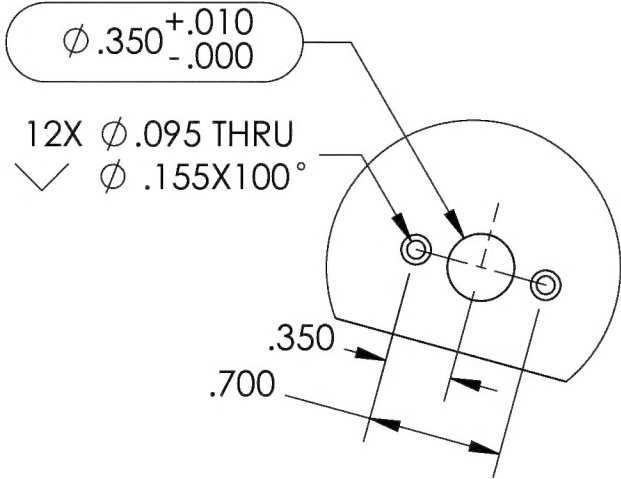
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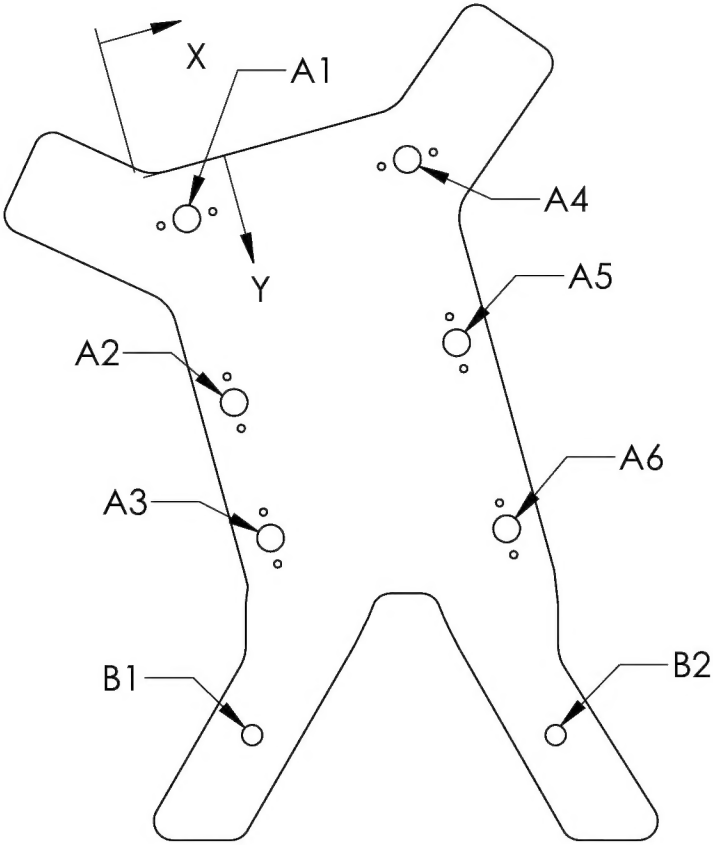
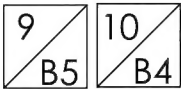
ORIGINAL DATE (MO-DA-YR) 08-19-10		DART 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO		
DRAWING APPROVAL P.BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 648.3500
		SCALE NONE	SHEET 8 OF 12

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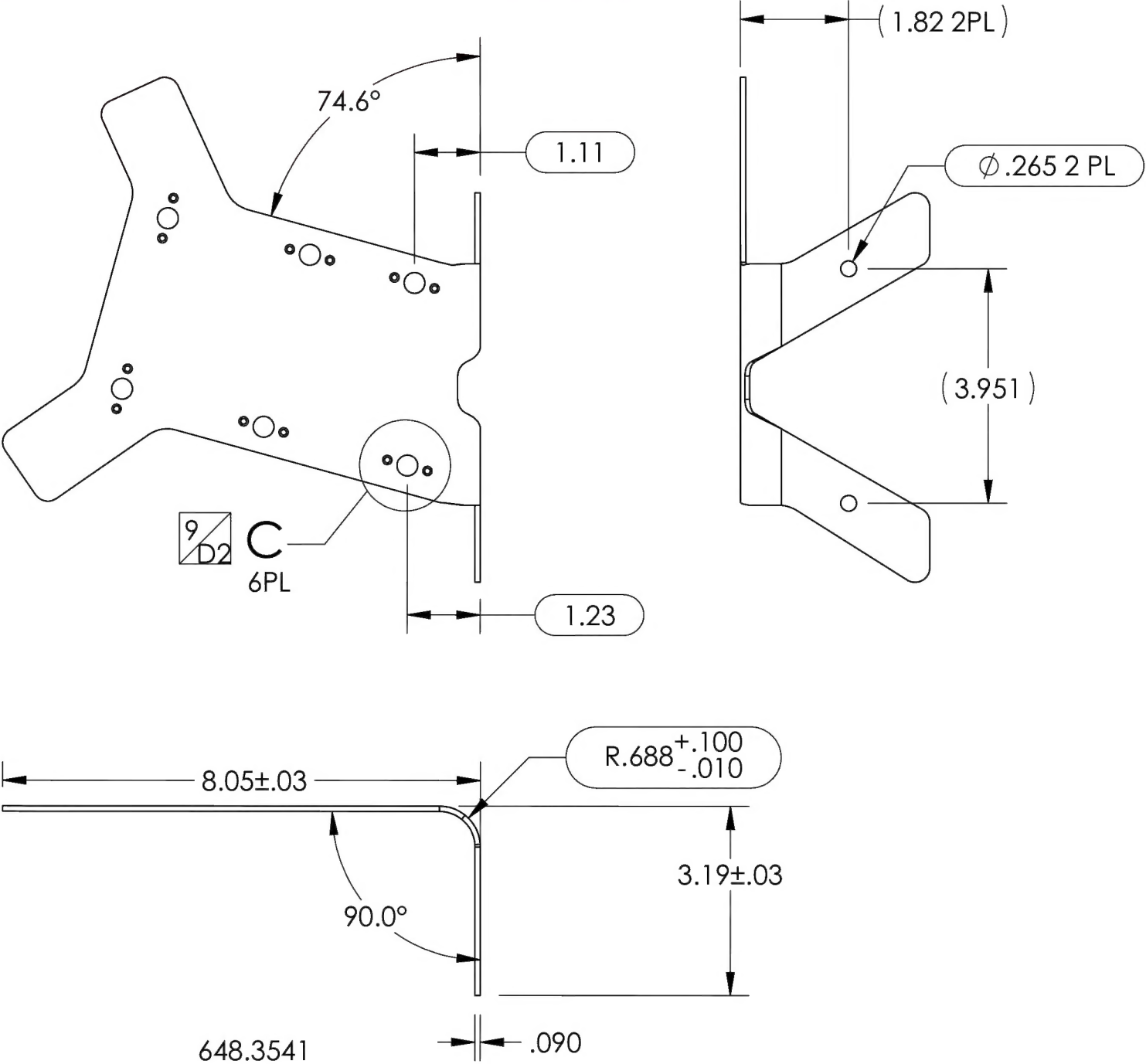
TAG	X LOC	Y LOC	SIZE
A1	.497	.665	Ø .350 THRU
A2	.457	3.135	Ø .350 THRU
A3	.448	4.961	Ø .350 THRU
A4	3.470	.681	Ø .350 THRU
A5	3.457	3.151	Ø .350 THRU
A6	3.444	5.658	Ø .350 THRU
B1	-.461	7.370	Ø .266 THRU
B2	3.348	8.416	Ø .266 THRU



DETAIL C

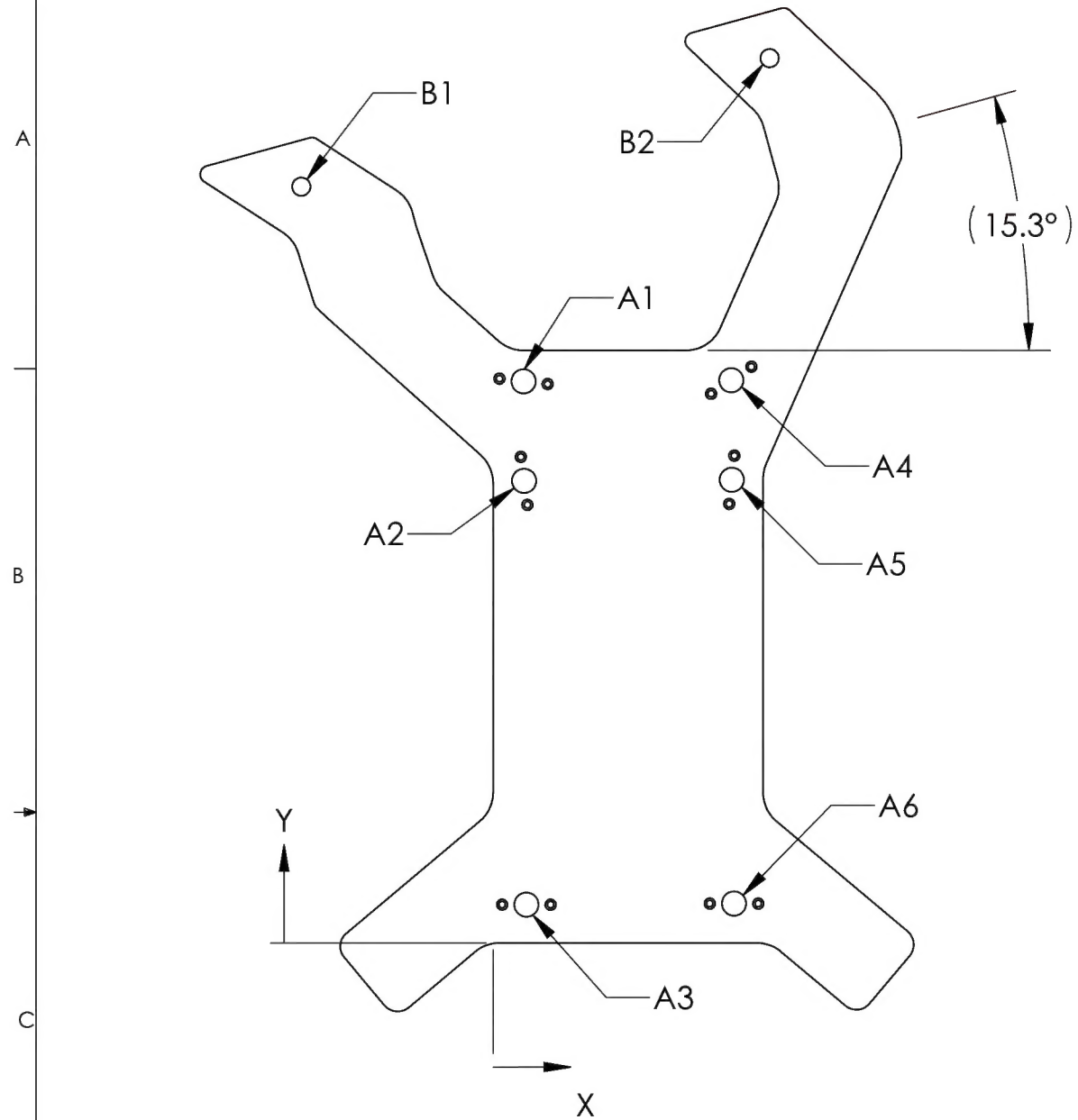


648.3541 - FLAT PATTERN 13



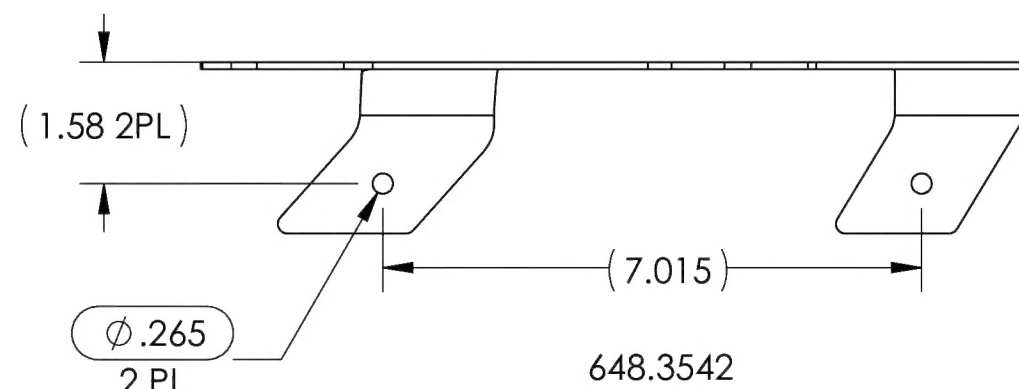
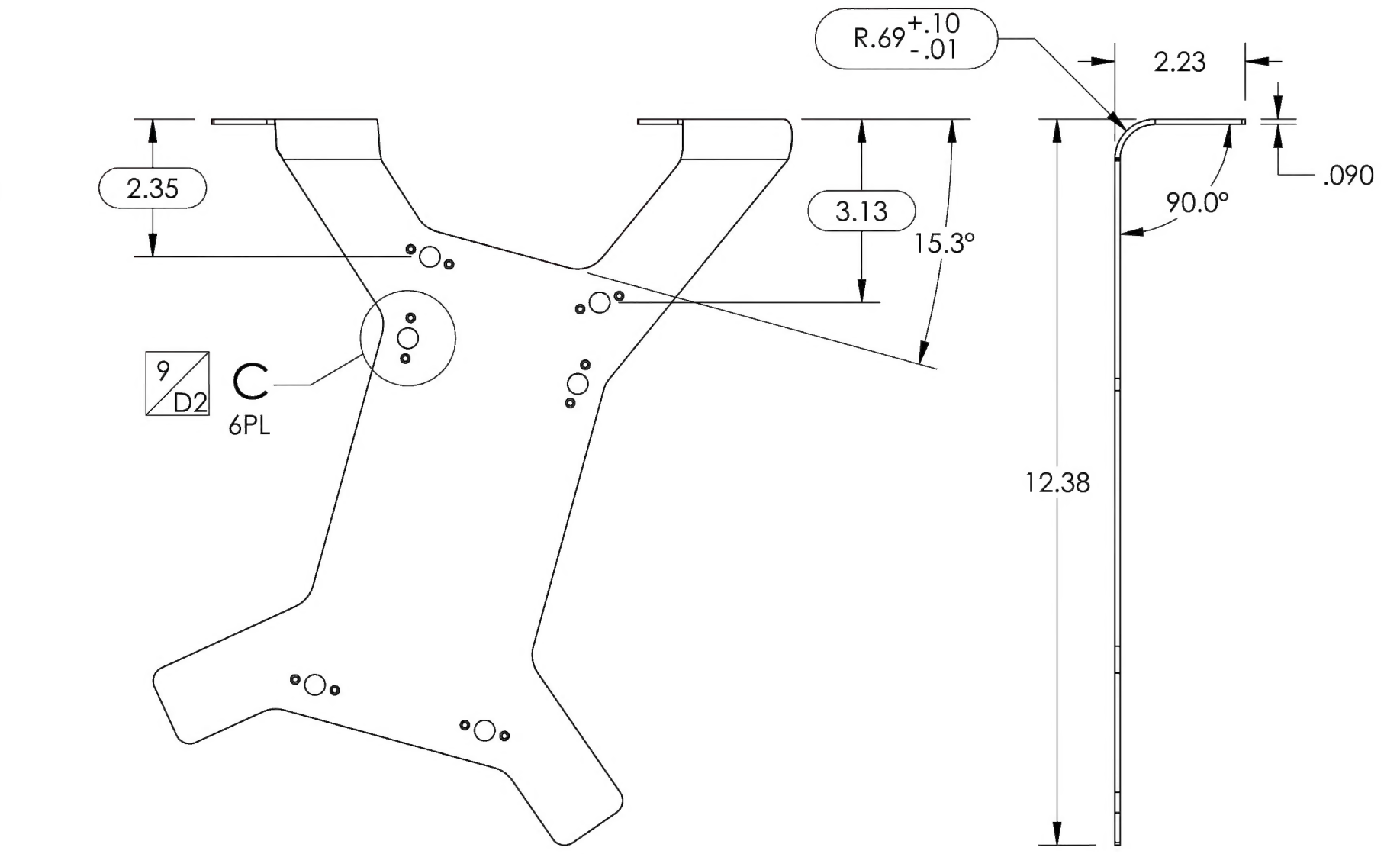
ORIGINAL DATE (MO-DA-YR) 08-19-10		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO	DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE	
DRAWING APPROVAL P.BRAVO 6-15-16		SHEETMETAL	
CONTRACT No.		REV. C	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6
		DWG. NO. 648.3500	SCALE NONE
		SHEET 9 OF 12	


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648.3542 - FLAT PATTERN 

TAG	X LOC	Y LOC	SIZE
A1	.440	8.111	Ø .350 THRU
A2	.448	6.673	Ø .350 THRU
A3	.480	.553	Ø .350 THRU
A4	3.440	8.126	Ø .350 THRU
A5	3.448	6.689	Ø .350 THRU
A6	3.480	.569	Ø .350 THRU
B1	-2.771	10.921	Ø .265 THRU
B2	3.994	12.778	Ø .265 THRU



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DRAWING APPROVAL P. BRAVO 6-15-16		APICAL INDUSTRIES, INC. dba DART AEROSPACE							
CONTRACT NO.		SHEETMETAL							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.001 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE	CAGE CODE	DWG. NO.				REV.	
		B	07MZ6	648.3500				C	
		SCALE NONE				SHEET 10 OF 12			

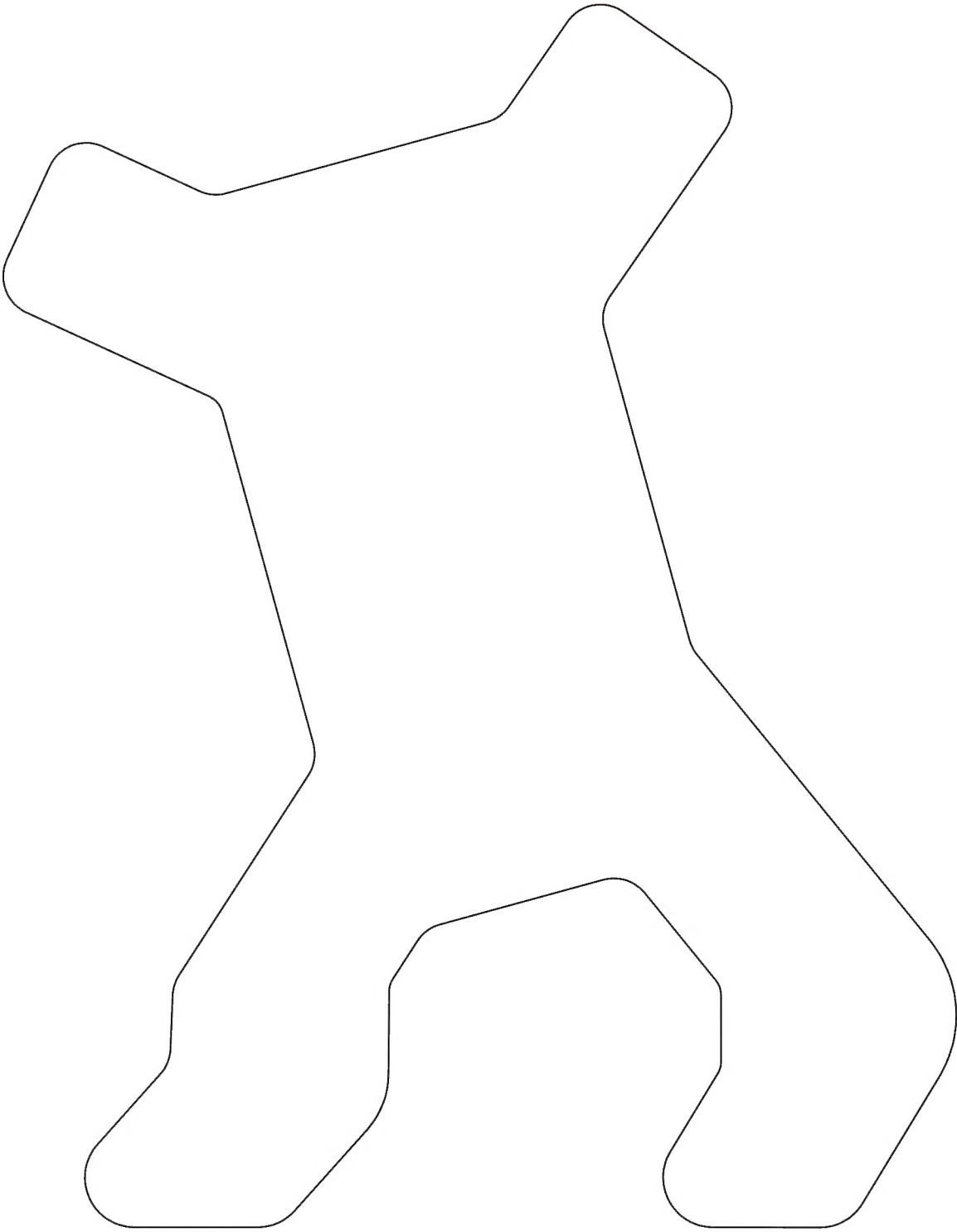
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A

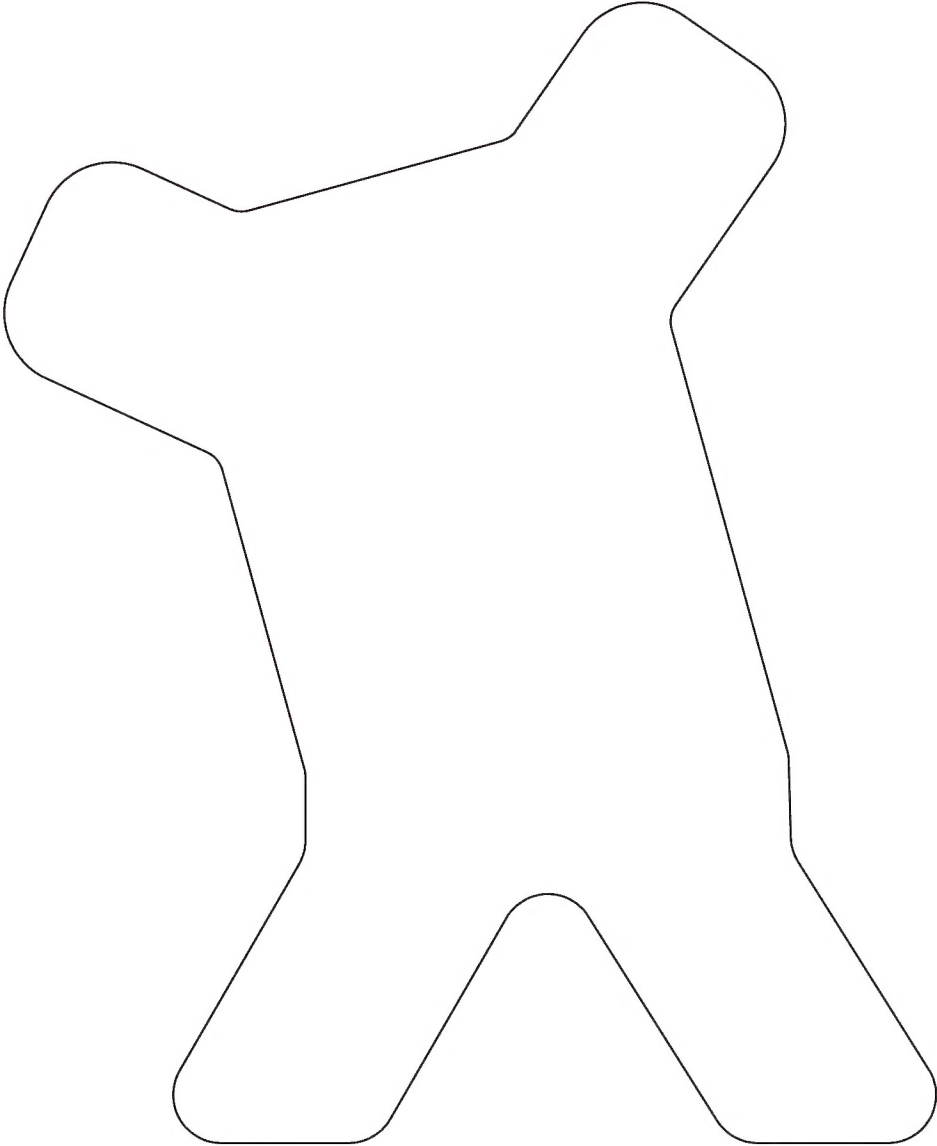
B

C

D



13 648.3544



13 648.3543

ORIGINAL DATE (MO-DA-YR) 08-19-10	
DRAWN BY E.ANDERSSON	CHECKER P.BRAVO
DRAWING APPROVAL P.BRAVO 6-15-16	
CONTRACT No.	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ± .5°

DART
AEROSPACE
APICAL INDUSTRIES, INC.
dba DART AEROSPACE

3030 ENTERPRISE CT.,
SUITE A
VISTA, CA. 92081
(760)-724-5300

SHEETMETAL			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500	REV. C
SCALE NONE			SHEET 11 OF 12

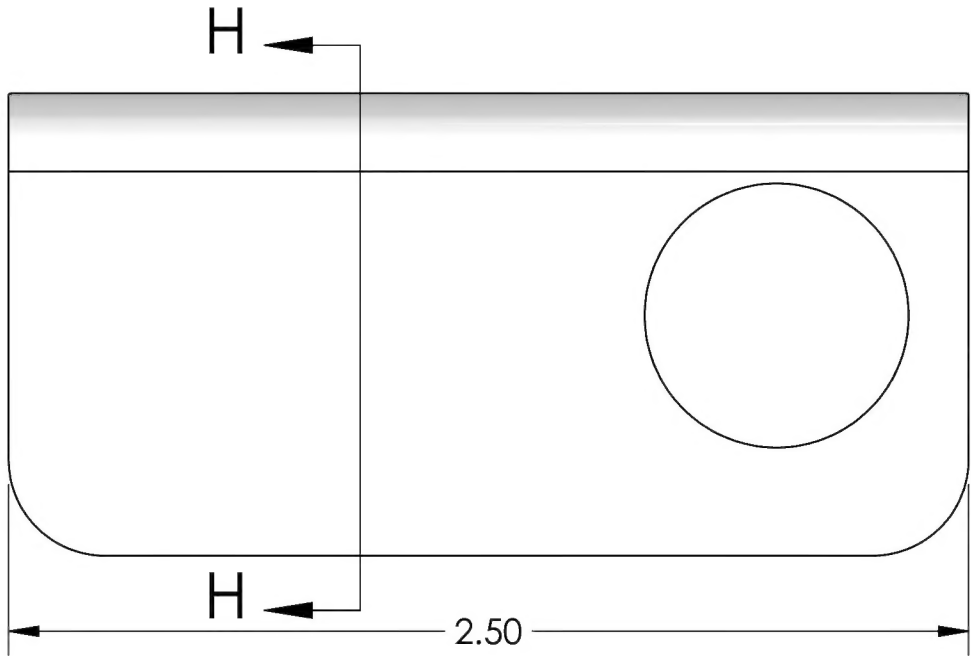
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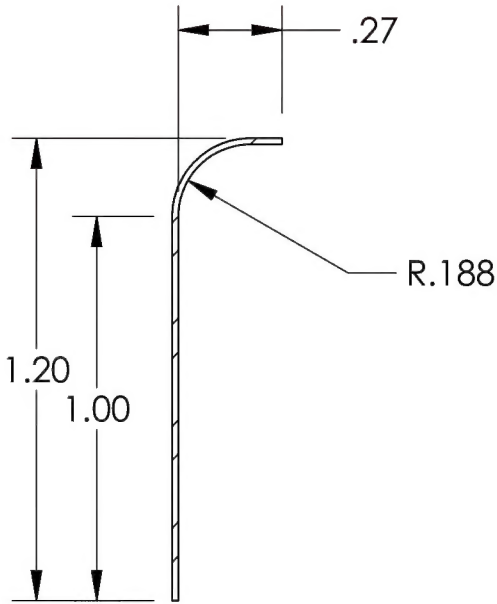
B

C

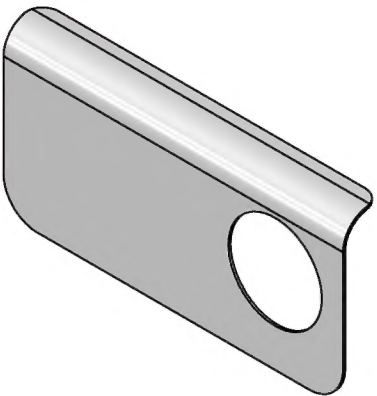
D



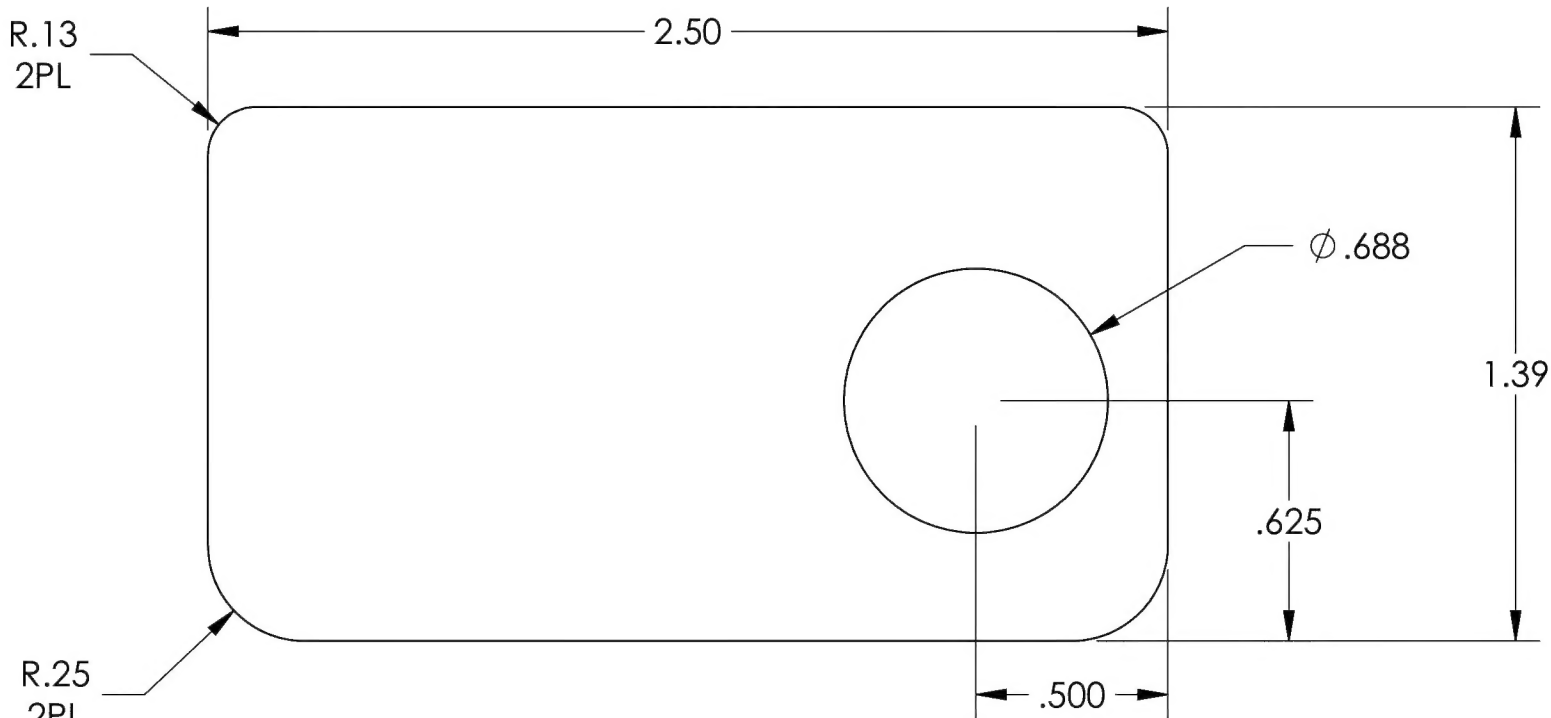
648.3547
648.3548 OPPOSITE




SECTION H-H
2 : 1



648.3547
648.3548 OPPOSITE



648.3547 AND 648.3548 FLAT PATTERN

ORIGINAL DATE (MO-DA-YR) 08-19-10		 DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E.ANDERSSON	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 6-15-16		SHEETMETAL			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 648.3500	REV. C
		SCALE NONE		SHEET 12 OF 12	